



**KEEPING YOUR FACILITY UP TO SPEED**  
— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103789**

Prepared for Arauco-Malvern MDF (10298)

1275 Willamette Rd  
Malvern AR 72104

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Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

**AC Inspection as Found**  
**Arauco-Malvern MDF (10298)**  
1275 Willamette Rd  
Malvern, AR 72104

FolderID: 103789  
FormID: 22332989

**AC Inspection - Rev. 2**

Location: LR MOTORSHOP

Serial Number:

Description: LENZE SERVO MOTOR

Hi-Speed Job Number: 103789

Manufacturer: LENZE

HP/kW: 75 (kW)

RPM: 3000 (RPM)

Frame: 160

Voltage: Other

Current: 138 (Amps)

Phase: Three

Hz: 101 (Hz)

Service Factor: 1.00

Enclosure: TEFC

# of Leads: 6

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

Shaft Machined Fit Repairs  
Required: Yes

Bearing Housing Machined  
Fit Repairs Required: No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: 2 - High 7 - Good

**Overall Condition**

1. Report Date

11/20/2024

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1.0

## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received		
Serviceable		
Initial Mechanical/Electrical		
5. Does Shaft Turn Freely?	(NA) Not Applicable	
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No	
7. Does Shaft Have Visible Damage?	(No) No	
8. Assembled Shaft Runout	Inches	
Na		
9. Assembled Shaft End Play	inches	
Na		
10. Air Gap Variation <10%		
Na		

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11. Lead Condition

(P) Pass



12. Lead Length

10 Inches

13. Does it have Lugs?, If so what is the Stud Size?

(Yes) Yes

14. Lead Numbers

U1V1W1-U2V2W2



15. Frame Condition

pass

16. Fan Condition

(P) Pass



17. Broken or Missing Components

na

### Initial Electrical Inspection

18. Insulation Resistance/Megger

0 Megohms

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19.	Winding Resistance		
	1-2	1-3	2-3
	Na		
	20.	Perform Surge Test	(F) Fail
	21.	Number of Stator Slots	48
	22.	Stator Condition	rewind



23. Stator Thermistors/Ohms	yes 379.4. ohms
24. Stator Overloads/Ohms	na
<b>Mechanical Inspection</b>	
25. Drive End Bearing Brand	NACHI
26. Drive End Lubrication Type	(Grease) Grease Lubricated
27. Drive End Bearing Insulation or Grounding Device?	
28. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
29. Drive End Bearing Condition	bad



30. Opposite Drive End Bearing Brand	NACHI
31. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
32. Opposite Drive End Bearing Insulation or Grounding Device?	
33. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer

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34. Opposite Drive End Bearing Condition

Old grease balls skidding on inner race



35. Drive End Seal

Na

36. Opposite Drive End Seal

Na

37. Drive End Bearing Number-

63132RS

38. Drive End Bearing Qty.

1

39. Drive End Bearing Type

(Ball) Ball Bearing

40. Opposite Drive End Bearing Number-

6212 2RS



41. Opposite Drive End Bearing Qty.

1

42. Opposite Drive End Bearing Type







(Ball) Ball Bearing

## Rotor Inspection

43. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	40
46. Rotor Condition	pass
47. List the Parts needed for the Repair Below 1-6313 2RS 1-6212 2RS BEARING	
48. Signature of Technician that Disassembled Motor	RW
	
<b>Mechanical Fits- Rotor</b>	
49. Shaft Runout	inches
 Na	
50. Rotor Runout	
Drive End Bearing Fit	Rotor Body
Opposite Drive End Bearing	
 Na	
51. Coupling Fit Closest to Bearing Housing	
0 Degrees	90 Degrees
120 Degrees	
 Na	
52. Coupling Fit Closest to the end of the Shaft	
0 Degrees	60 Degrees
120 Degrees	
 Na	
53. Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
120 Degrees	
 Bad	

54. Drive End Bearing Shaft Fit Condition

(F) Fail



55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3625

2.3625

2.3625

56. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Pass

**Mechanical Fits- Bearing Housings**

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.5127

5.5127

5.5127

59. List Machine Work Needed Below

*De shaft bearing fit bad .Recommend new shaft or weld fit*

60. Technician

RW

*[Handwritten signature]*

Co sign:CRW

61. Drive End - Endbell Bearing Fit Condition

(P) Pass



62. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.3307	4.3307	4.3307
63. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass



64. Bearing Cap Condition	
Drive End Bearing Cap	Opposite Drive End Bearing Cap
pass	pass



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65. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<div> <div></div> <div>Pass</div> </div>		
<b>Root Cause of Failure</b>		
66. Failure locations		
<i>De bearing</i>		
67. Root cause of failure		
<i>Carriage came apart letting rotor drop and drag the iron of winding and shortening to ground</i>		
<b>Dynamic Balance Report</b>		
68. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
69. Initial Balance Readings		
Drive End	Opposite Drive End	
70. Final Balance Readings		
Drive End	Opposite Drive End	
71. Technician		
<b>Rewind</b>		
72. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
73. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
74. Post Rewind Electrical Test- Insulation Resistance		
75. Post Rewind Polarization Index		
76. Post Rewind Winding Resistance		
1-2	1-3	2-3
77. Post Rewind Surge Test		
78. Post Rewind Hi-Pot		
79. Technician		
<b>Mechanical Fits- Rotor - Post Repair</b>		
80. Shaft Runout Post Repair		
81. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
82. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
83. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
84. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees

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85. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
86. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
87. Shaft Repair Sign-off			
<b>Assembly</b>			
88. QC Check All Parts for Cleanliness Prior to Assembly			
89. Photograph All Major Components prior to assembly			
90. Final Insulation Resistance Test			
91. Assembled Shaft Endplay			
92. Assembled Shaft Runout			
93. Test Run Voltage			
Volts	Volts	Volts	
94. Test Run Amperage			
Amps	Amps	Amps	
95. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
96. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
97. Ambient Temperature - Fahrenheit			
98. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
99. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
100. Document Final Condition with Pictures after paint			
101. Final Pics and QC Review			



Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

## AC Random Coil Rewind Report

FolderID: 103789  
FormID: 22336512

### Arauco-Malvern MDF (10298)

1275 Willamette Rd  
Malvern, AR 72104

LR MOTORSHOP  
Winding

Priorities Found: ● 2 - Good

General	
1. Job Number	103789
2. Report Date	11/20/2024
3. Customer	Arauco
Stator Winding	
4. Core Length	9.75 "
■ 3.375 con head 3.5 with connection 3.5 opp connection head	
5. Core ID	7.625 "
6. Back Iron Depth	1 "
7. Slot Depth	1.25 "
8. Tooth Width	0.25 "
9. Number of Vents	0
10. Vent Width	0 "
● 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	W/lbs.
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	
20. RTD's	
21. RTD's Reading	
22. Motor Heaters	
23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
● 26. Thermistors	(Y) Yes
27. Number of Poles	4
28. Slots	48
29. Number of Coils	48
30. Coil Weight	
31. Lead Markings	
1-6	

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32. Grouping 12g 4 c
33. Multiple Wires
34. Wire Size
35. Turns per coil
36. Pitch 1 to:
37. Connection
38. Lead Length
39. Lead Size
40. Number of Leads
41. Megger Reading After Rewind
42. Coil Machine Slot
43. Coil Machine Tip
44. Coil Machine Pitch
45. Hi Pot Reading After Rewind
46. Surge Pattern After Rewind
47. Service Technician



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